

Work Order ID 86872

86872

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July-06-12 3:19:24 PM

Item ID: D3417-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Washer
 Start Date: 7/06/12 Start Qty: 50.00 *50* Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 50.00 *50* Customer:
 Reference:

Approvals: Process Plan: P Date: 12-07-10 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3417	Rev F								

100 Hardinge CNC LATHE SMALL 0.00
 100
 Doosan Memo 0.00
 Doosan Lathe 1-Turn as per Folio FA761
 Rev: _____ &
 Dwg D3417 Rev: _____
 2-Deburr

DAS
13
9-89

12/7/30

5-1

110 QC2- Inspect parts off machine FAI/FAIB 0.00
 110
 QC Memo 0.00
 Quality Control

DAS
13
9-89

12/7/30

51

120 QC8- Inspect parts - second check 0.00
 120
 QC Memo 0.00
 Quality Control

5mb
12-7-30

DAS
14
9-89

12/02/30

51
Wester

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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86872

Page 2

Item ID: D3417-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Washer

Start Date: 7/06/12

Start Qty: 50.00

50

Cust Item ID:

Required Date: 8/10/12

Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

0.00

Packaging

5/10

12/7/30 SP

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/7/31 SP

MCS 12/07/30

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 86872

Parent Item: D3417-5

Parent Item Name: Washer

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev: A New issue 08-07-09 JLM Verified By: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELNR1.2500 DELRIN ROUND BAR 1.25"		Purchased	No			110	f	7.4200	0.0296	1.557895			

Location

Loc Qty

Loc Code

MAT055

7.42

119133

0.92

121971

6.5

2Rt DAS 13 12/7/30
2-89

2Rt

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DART AEROSPACE LTD		Work Order:	86872
Description: Washer		Part Number:	D3417-5
Inspection Dwg: D3417	Rev: EFC 12.07.18		Page 1 of 1

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W/O:		WORK ORDER CHANGES					
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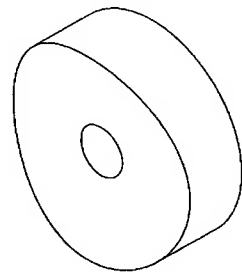
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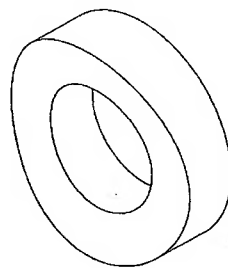
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 86872

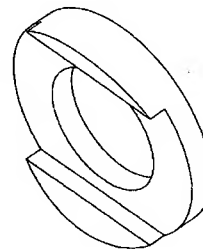
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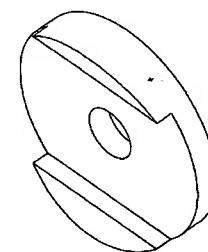
D3417-1 WASHER



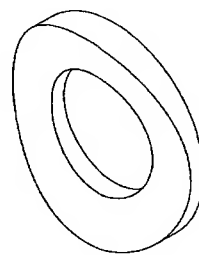
D3417-3 WASHER



D3417-5 WASHER



D3417-7 WASHER



D3417-9 WASHER

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2010-09-15
WJ

NOTES:

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD
REF DART SPEC M-DELRIN-R
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR
REF DART SPEC M-DELRIN-B
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET
REF DART SPEC M-DELRIN-S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3417-1, 0.020 lbs
D3417-3, 0.010 lbs
D3417-5, 0.010 lbs
D3417-7, 0.010 lbs
D3417-9, 0.004 lbs

F	ADD D3417-9 (ZN B5-3)	SC	10.07.26
E	ADD D3417-7 (ZN A2-2)	RF	09.06.30
D	ADD .5 WASHER (ZN B2-1, B2-2); REFORMAT TO "B" SIZE & UPDATE TO CURRENT STANDARDS; REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CBORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
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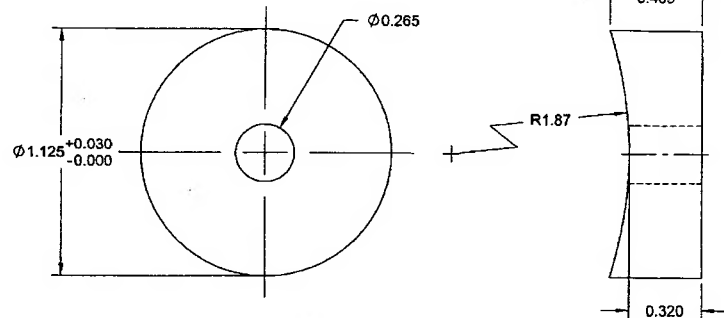
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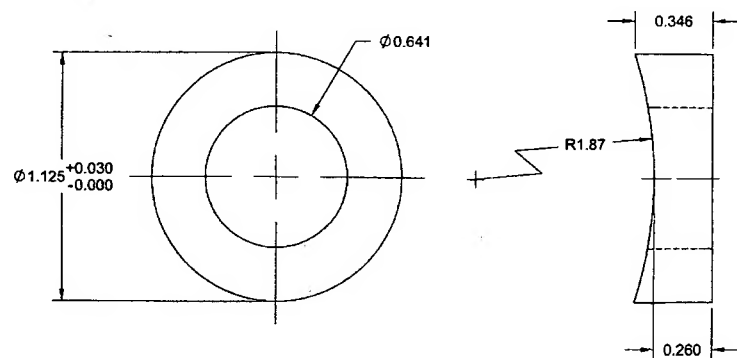
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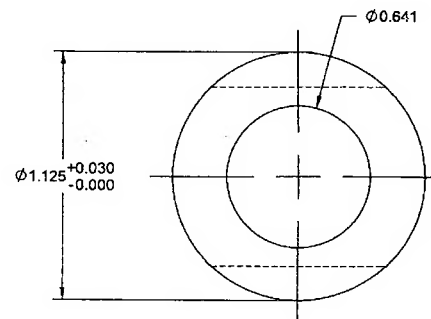
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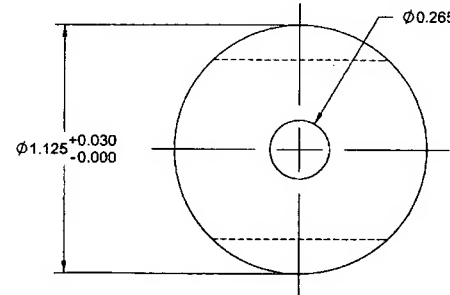
D3417-1 WASHER



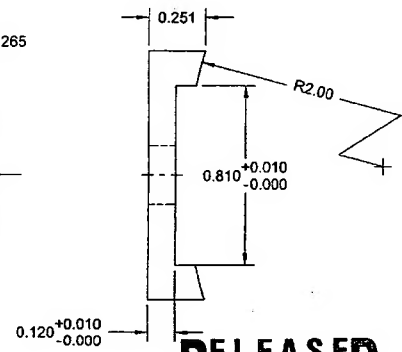
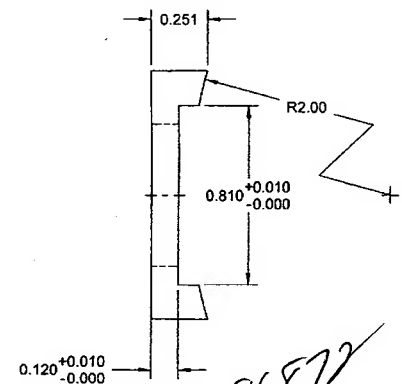
D3417-3 WASHER



D3417-5 WASHER



D3417-7 WASHER



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2010-09-15

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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 2 OF 3
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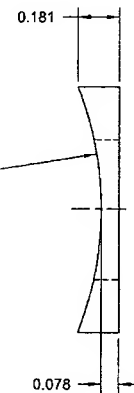
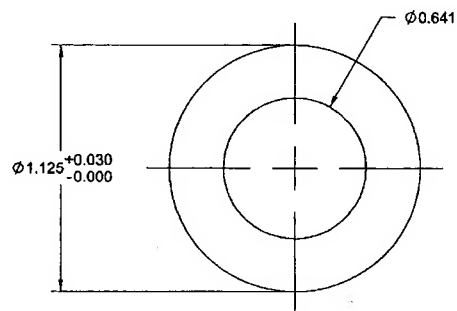
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D3417-9 WASHER



86872

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2010-09-15
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DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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